Work Order ID 68459

Wednesday, April 13, 2011 3:29:02 PM

Item ID: D3915-041 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Light Lid Assemby, Long Basket

Start Date: 4/13/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/20/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** H **Date:** 11-04-[illegible] **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3915	C

100 Large Fab Large Fab

Weld per dwg A/R Aluminum rod Batch: 112860 0.00

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

GL 11-04-15

110 QC Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo 0.00

1 0 BE 11/04/18

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68459

Wednesday, April 13, 2011 3:29:02 PM

Item ID: D3915-041

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Start Date: 4/13/2011 **Start Qty:** 1.00

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Run **Start**

Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00				1	ϕ		
Hand Finishing	***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***								
140	Weld per dwg A/R Aluminum rod Batch: 112860	0.00							
Large Fab	Memo	0.00							
Large Fab	1- weld (4) corners								

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Run Start / Stop

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds **Memo**	0.00 0.00				1	Ø	8E 11/04/20	
155 QC Quality Control	QC6- Inspect dimensions to drawing **Memo** ***inspect fit of lid with base***	0.00 0.00 8 11/4/20				(8)			
157 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo** 1- realodine corners ***do not acid etch***	0:00 0.00				1		BH 11-4-20.	

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1		BR	11-4-20
	M116964. Memo 1- touch up corner with alodine only 2- Plug holes prior to 1ST COAT: START TIME: 2:00 OVEN TEMPERATURE: 320° FINISH TIME: 3:20 ****************** 2nd coat if necessary********************* 2ND COAT: START TIME: ____ OVEN TEMPERATURE: ____ FINISH TIME: ____	0.00							
170 QC Quality Control	QC3- Inspect Part Finish	0.00							11/04/25 (1)
	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ______________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68459

Wednesday, April 13, 2011 3:29:02 PM

Item ID: D3915-041 **Accept**

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Item Name: Light Lid Assemby, Long Basket

Setup Start / Stop

Start Date: 4/13/2011 **Start Qty:** 1.00

Required Date: 4/20/2011 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 HandFinish Hand Finishing	Assemble as per dwg **Memo** 1- Install webbing as per dwg 2- Install placard and label as per dwg	0.00 0.00				EJ 11/04/25			
190 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	S 11/04/26						
200 Packaging Packaging	Identify as per dwg & Stock Location: 6-A **Memo** W/O 68457	0.00 0.00				EJ 11/04/25			

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68459

Wednesday, April 13, 2011 3:29:02 PM

Item ID: D3915-041

Accept

Setup **Start** **Stop**

Revision ID:

Item Name: Light Lid Assemby, Long Basket

Start Date: 4/13/2011 **Start Qty:** 1.00

Required Date: 4/20/2011 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00						11/4/26	
QC	**Memo**	0.00							
Quality Control									

CMF 11-04-26

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W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 3:29:45 PM

Work Order ID: 68459

Parent Item: D3915-041

Parent Item Name: Light Lid Assemby, Long Basket

Start Date: 4/13/2011 **Required Date:** 4/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 Mounting Plate		Manufactured	No			100	Each	7.0000	4	4	Cp 11.04.14		
D3915-1 Rib		Manufactured	No			100	Each	0.0000	2	2	B68511 → ② Cp 11.04.14		
D4016-5 Hinge Half, Light Lid		Manufactured	No			100	Each	9.0000	3	3	Cp 11.04.14		
D4019-3 Rib		Manufactured	No			100	Each	9.0000	3	3	Cp 11.04.14		

D2957 locations:

Location		Loc Qty	Loc Code	
WA005		7		
	63750	7		④

D4016-5 locations:

Location		Loc Qty	Loc Code	
WA005		9		
	66335	8		②
	66541	1		①

D4019-3 locations:

Location		Loc Qty	Loc Code	
WA006		9		
	66726	9		③

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Wednesday, April 13, 2011 3:29:46 PM

Work Order ID: 68459

Parent Item: D3915-041

Parent Item Name: Light Lid Assemby, Long Basket

Start Date: 4/13/2011 **Required Date:** 4/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

Item	Type								
D4035-045 Lid Rib Assembly, Fwd (Light)	Manufactured	No		100	Each	2.0000	1	1	Cp/11·04·14
		Location		**Loc Qty**	**Loc Code**				
		WA006		2					①
			67821	2					
D4035-047 Lid Rib Assembly, Aft (Light)	Manufactured	No		100	Each	2.0000	1	1	Cp/11·04·14
		Location		**Loc Qty**	**Loc Code**				
		WA006		2					①
			67822	2					
D4056-1 Label Plate	Manufactured	No		100	Each	3.0000	1	1	Cp(11·04·14
		Location		**Loc Qty**	**Loc Code**				
		WA005		3					①
			58308	1					
			59750	2					
D2728-1 Dart Logo label	Manufactured	No		180	Each	0.0000	1	1	SS 11/04/25
D4029-041 Webbing (Long Basket)	Manufactured	No	B 68043	180	Each	0.0000	1	1	SS 11/04/25

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 13, 2011 3:29:47 PM

Work Order ID: 68459

Parent Item: D3915-041

Parent Item Name: Light Lid Assemby, Long Basket

Start Date: 4/13/2011 **Required Date:** 4/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

Item	Type		Qty	Unit			
MS20600-AD4W3 Cherry Rivets	Purchased	No	180	Each	877.0000	34	34

Location		Loc Qty	Loc Code	
ST321		456		
	111636	456		34
WA018		421		
	107939	421		

Item	Type		Qty	Unit			
NAS1149DN416J Washer	Purchased	No	180	Each	385.0000	34	34

Location		Loc Qty	Loc Code	
ST298		385		
	114348	11		
	114597	289		34
	13910	85		

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

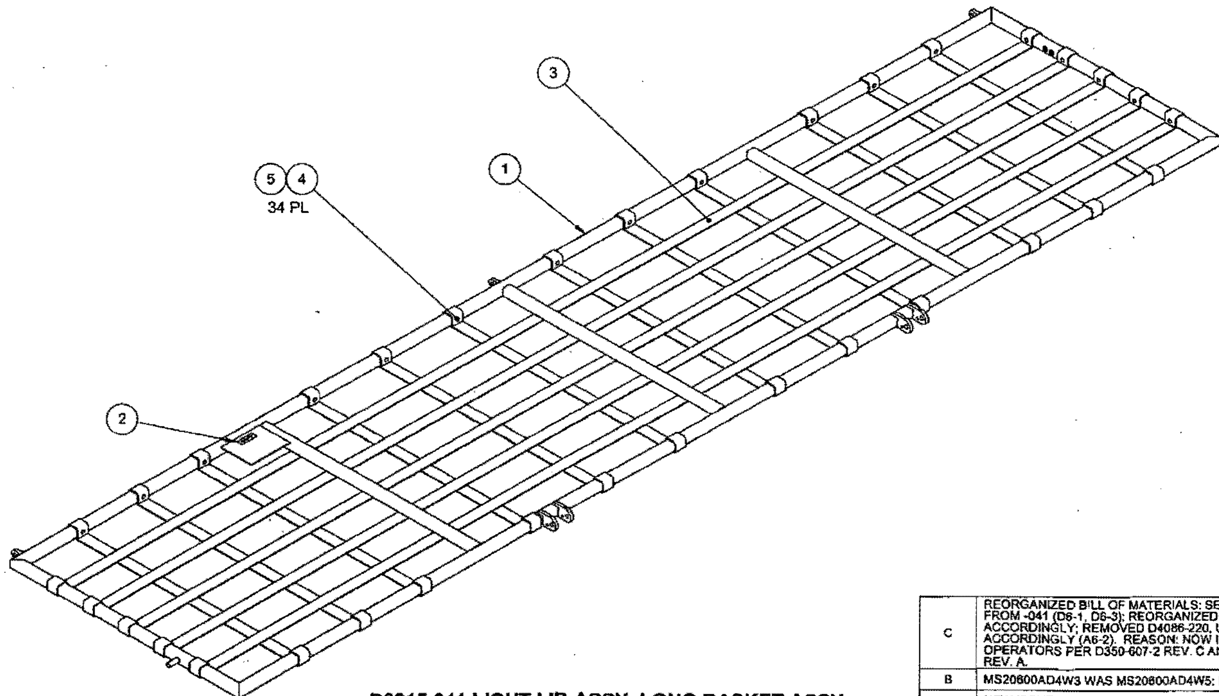
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68457

11-04-13



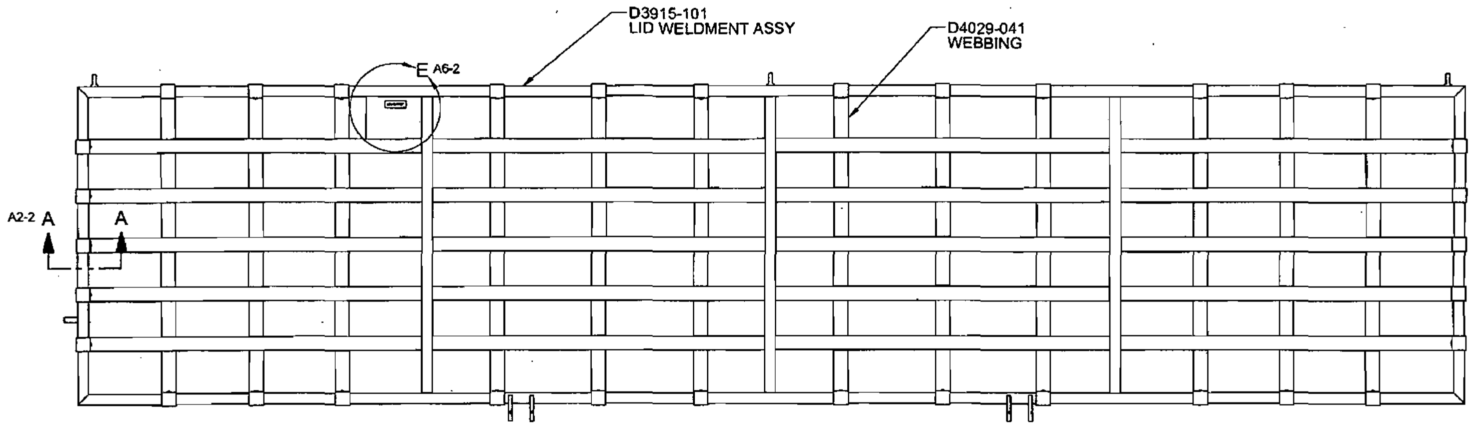
D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
10.08.12
ECN 10-596

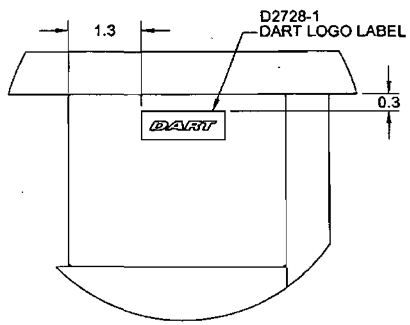
REV.	DESCRIPTION	BY	DATE
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 6.91 lbs

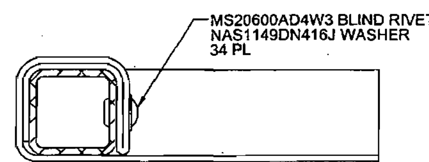
DESIGN	ALS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3915	REV. C SHEET 1 OF 4
MFG. APPR.			
APPROVED		TITLE LIGHT LID ASSY-LONG BASKET	SCALE NTS
DE APPR.			
DATE	10.08.05		



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



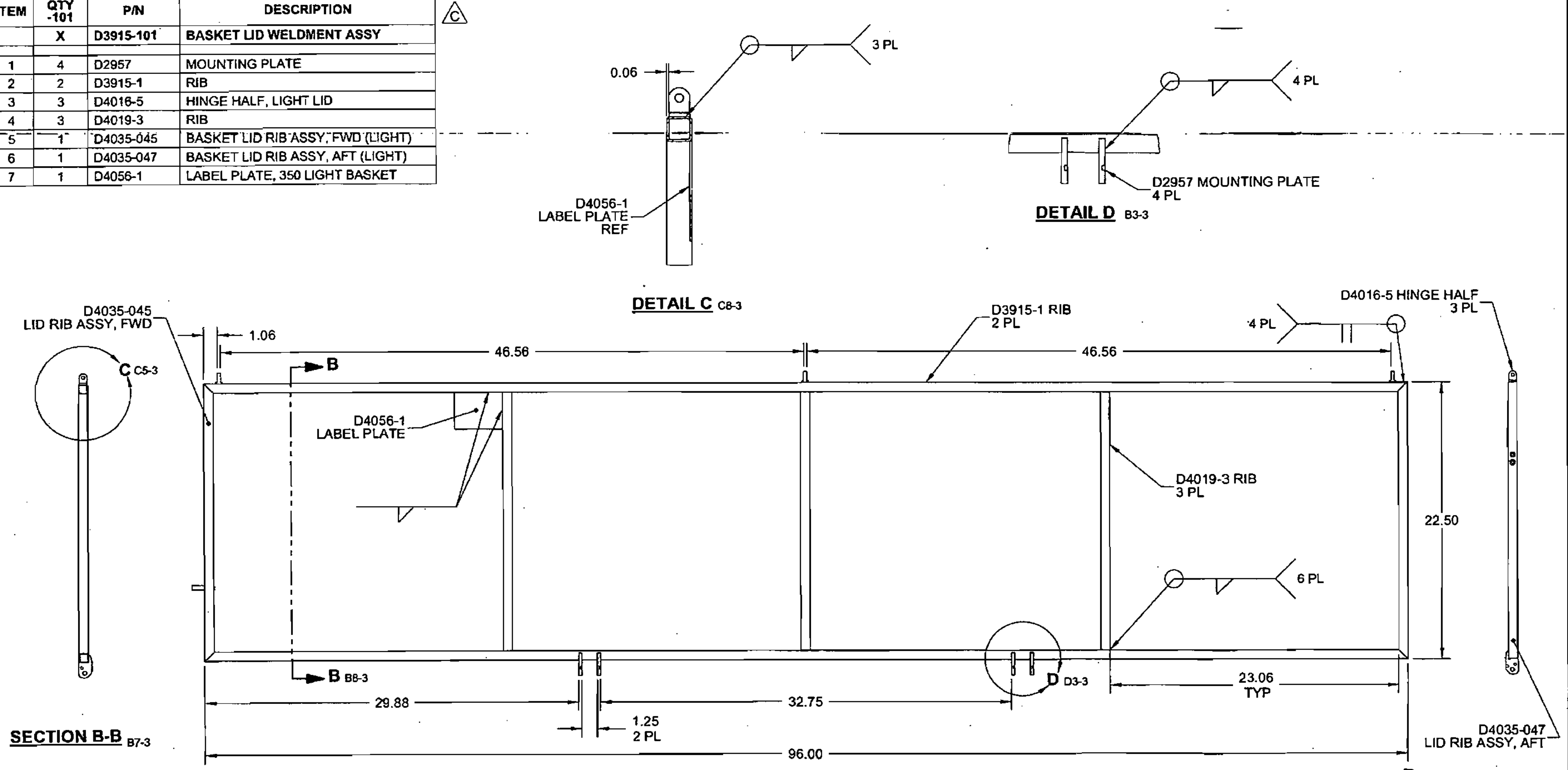
SECTION A-A C8-2

a 10 68459

RELEASED 10.08.12

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3915	REV. C SHEET 2 OF 4
MFG. APPR.			
APPROVED		TITLE LIGHT LID ASSY-LONG BASKET	SCALE NTS
DE APPR.			
DATE	10.08.05		

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



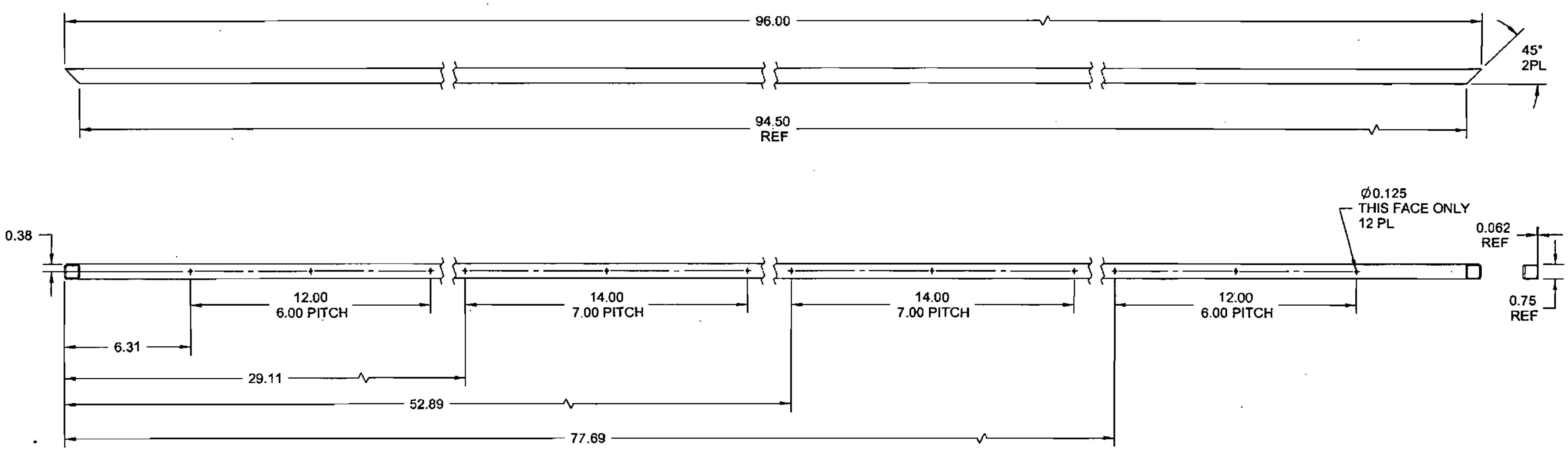
D3915-101 BASKET LID WELDMENT ASSY

RELEASED 10.08.12

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 4.81 lbs
8) WELD PER DART QSI 004

w1068459

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3915 — REV. C — SHEET 3 OF 4
CHECKED		
MFG. APPR.		TITLE: LIGHT LID ASSY-LONG BASKET — SCALE: NTS
APPROVED		
DE APPR.		
DATE	10.08.05	



D3915-1 RIB

u/o 68459

RELEASED 10.09.12

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.49 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3915 — REV. C — SHEET 4 OF 4
CHECKED	SC	
MFG. APPR.		TITLE: LIGHT LID ASSY-LONG BASKET — SCALE: NTS
APPROVED		
DE APPR.		
DATE	10.08.05	